Work Orde					*1(136	78*							Page 1
Revision ID:	D2938- 206 Sado	l lle Left side			Accept	*	_. N900	<u>040</u>	100	ገ*	Setup	Start Stop	*N: *N:	S1* S2*
Start Date: Required Date: Reference:	7/01/13 7/05/13	Start Qu Req'd Q		*6* *6*		·•	Cust Item I Customer:	D:						
Approvals:	Proces	s Plan:	5	Date: 13-06-	Z< Tooling:		D:	ate:	-		Run	Start	*N	R1*
				Date:		****	D:	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Descript			Set Up/ Run Hou	rs	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt	•	Reject Number	Insp. Stamp
Draw Nbr		Revision Nbr												
D2938		Rev C						·						
100					0.00					_	·			
100 HAAS I		HAAS CN	C VERTICA Memo	AL MACHINING #1	0.00					6				XB-8-19
HAAS CNC vertical	machine	¥1	Program p number ar inspect as	part number and batch number programmed correctly.2 per dwg D2938 & attachend visually inspect as per	-Machine Step No 1 o	of Folio and	l visually							
*110 *110*		CONVEN	ΓΙΟΝΑL MI	ILLING MACHINE	0.00	1045	3/08/2	27		6	4	_e		
Mill Conv			Memo		0.00						_ <i>_</i>			
Conventional Millin	g Machine	:	Machine I	Keyway and inspect per att		et								
120		QC1- Insp	ect dimensio	ons to dimension sheet	0.00	PAO.	,			1				
120 ^{QC}			Memo		0.00	3-8°	12/08/2	2	•					11 13-8-19
Quality Control							,	ı						

DQA:			Date:										TOADT
	3					WORK ORDER NON-	-CC	ONFO	RMANCE / UI	PDATE			AEROSPACE
QA Closed:			Date:							<u> </u>	Work Order u	pdate only	
Work Orde	er:					DISPOSITION				AGAINST I	DEPARTMENT	/PROCESS	
		•				Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		-				Use-as-is		Thern	noforming	Finishing		re/Packaging	Other
NCR I	No					Suspected Unapproved			Large Fab	Composite		Supplier	
	T								<u> </u>				
Root		ŀ	_	i <u>.</u> ;	Desci	ription of work order update		nitial	Act		Sign &		
Cause	Da	ite	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design			5										
Doc/Data	 	-	8										
Equip/Tooling	H	- 1									-		
Handling/Pre	H												
Material	 		:								1		
Operator Offset/Setup	H	-											
Process	H	1											
Supplier	H												
Training									!]		
Transport		1											
Unapproved	\square												
		<u> </u>				· · · · · · · · · · · · · · · · · · ·	FAI	ULT CAT	EGORY		1		
Landi	ng Gear					General .		_					
	Bend	ling				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
	Cent	re Not	Concen	itric		BOM/Route		Grain	•	Γ	Over/Under	tolerance	Set-up
	Crack	ks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct [Temperature/Cure
	Crim	p/Kink,	/Ripple,	/Wave		Burrs		Inspect	on Incomplete/Un	qualified	Part Lost/M	issing	Weld
	Cuffs	5				Contamination		Instruct	ions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
	Crust	hing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_
	⊢	Treat				Cut Too Short :		Mislabe	led		Power Loss/	Surge	Other
			Strip in	Tube		Drawing		Misread	i				<u>-</u>
		cs/Chat			<u> </u>	Drill Holes		Off-set					····
	⊢	_	quence			Finish		i	Calibration				
	Wave	e/Twist	t in Tub	e		Fit/Function		Out of S	equence				

Work Orde June-24-13 2:1		03678		*10	367	ጸ*						Page 2
Item ID: Revision ID: Item Name:	D2938-1 206 Saddle	Left side		Accept	*N	1900	040	100)* s	etup Start Stop	14	S1* S2*
Start Date: Required Date: Reference:	7/01/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			Cust Item I Customer:	D:				IV	. . 7
Approvals:	Process P	Plan:	Date:	Tooling:		. Da	ate:		R	tun Start	1/	R1*
	QC:		Date:	SPC (Y/N):		Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description	1	Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		QC8- Inspect parts - secon	nd check	0.00	A.	1010	0122		,	1		OAS
130 QC Quality Control		Memo		0.00	\$.E	13/0	0/22		. 6	<u> </u>		08
140		Chemical Conversion Co.	at per QSI005 4.1	0.00					6	9	p -	8-8-20
140 HandFinish Hand Finishing		Memo		0.00						<u></u>	<u> 1 / O</u>	
150		White Gloss(Ref:4.3.5.1)	per QS1005 4.3-Alum	0.00					64	12/11	1 /	14/0
150 Powder Coating	* *	Memo START TIM	TIVE 11/01 L (1971) 417	OVEN TEMPERATUI	RE:				OX	<u>9 11</u>	1/1/_	<u> 13/08</u> ,
m/3P/g	5	3972		गग०								
W G												

DQA:		_ Date:										-	TOAC
0.5		0-4-			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:		Date:		1					Wo	rk Order up	date only		
Work Orde	er:				DISPOSITION			AGAINST	DEP	ARTMENT	/PROCESS		
	-;				Rework]		Skid-tube Crosstube			Water Jet		Engineering
Part N	lo.				Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	7	Quality
				_	Use-as-is		Therr	noforming Finishing	П		e/Packaging	1	Other
NCR N	lo			_	Suspected Unapproved			Large Fab Composite			Supplier		
Root				Desci	ription of work order update	1	nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	,	QC Inspector
Design													
Doc/Data													
Equip/Tooling	_												
Handling/Pre							']	
Material 경단													
Operator ,	\dashv											ł	
Offset/Setup	_								·				
Process													·
Supplier Training	ᅱ	1											
Transport	\dashv												
Unapproved		`											
· · ·		1			• • • • • • • • • • • • • • • • • • • •	FAI	ULT CAT	regory		<u> </u>		1	
Landir	ng Gear			,	General								
[Bending				Bend		Folio/P	rogram ·		Dutside Dime	ensions	Pr	essure/Forced
[Centre N	ot Concei	ntric		BOM/Route		Grain	_	П	Over/Under	tolerance	Se	t-up
	Cracks				Broken/Damage/Defect		Hardwa	re	П	Part Incorrec	t [Te	mperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mis	ssing	w	eld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		\square w	rong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		Positioned W	/rong		
[Heat Tre	at			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Ot	her
	Inspectio		Tube		Drawing		Misread		_				
	Marks/Cl				Drill Holes		Off-set		_				
ļ	Turning S	•			Finish	L	4	Calibration	_				,
	Wave/Tv	vist in Tub	e e		Fit/Function		Out of S	Sequence					

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Work Orde		3678		*	103	3678	3*						Page 3	}
tem ID: Revision ID: tem Name:	D2938-1 206 Saddle Le 7/01/13	eft side Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	Accept		Cı	900 est Item I	040	100)* s	Setup Sta	I	S1* S2*	=
Approvals:		an:	Date:		_			ate:	-	I	Run Sta Sto)1)	R1*	
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC3-Inspect Part Finish Memo		Set U Run 0.00	Нейся 27 9-89	1 107	Cool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
170 *170* Packaging Packaging		Identify as per dwg & Sto Memo	ck Location: <u>5743</u>	0.00						6x	(¶	1.10.	13-08	-17
*180 *180* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00							13/	8/29	D	
												NB	68-28	

DQA:			Date:			_								TO AC
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
QA Closed:			Date:						_	W	ork Order u	odate only		<u>, </u>
Work Ord	er.					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
						Rework			Skid-tube Crosstub	وا	7	Water Jet		Engineering
Part	No.					Scrap			Machining Small Fa	_	Pro	d. Eng. Coor.		Quality
						Use-as-is			noforming Finishin	-	-	re/Packaging		Other
NCR	No.					Suspected Unapproved			Large Fab Composit	ϵ		Supplier		
		1	1						· · · · · · · · · · · · · · · · · · ·					
Root					Desc	ription of work order update		Initial	Action		Sign &			
Cause	1	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	n	QC Inspector
Design	\vdash					•								
Doc/Data	-]											
Equip/Tooling Handling/Pre	\vdash		1											
Material													Ī	
Operator	\vdash													
Offset/Setup	Н												İ	
Process	П													
Supplier														
Training														
Transport												٠,		
Unapproved												**		
				-		,	FAI	ULT CAT	regory					<u> </u>
Landi						General	 ,	1		_	7	,		
	\vdash	Bending			<u> </u>	Bend			rogram et al.		Outside Dim		_	Pressure/Forced
	${}$	Centre No	ot Concen	itric	<u> </u>	BOM/Route		Grain		<u> </u>	Over/Under		_	Set-up
	\vdash	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	į.	_	Temperature/Cure
	\vdash	Crimp/Kir	ik/Ripple,	/Wave	_	Burrs			ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
	-	Cuffs			-	Countamination	\dashv	9	ions Incomplete/Unclear	\vdash	Part Moved	[Wrong Stock Pulled
		Crushing Heat Trea	+ •		-	Countersink Cut Too Short	-	1	ned/off center	-	Positioned V	~ r	<u> </u>	Other
		Inspection		Tubo	-	Drawing		Mislabe Misread			Power Loss/	ourge [Other
	\vdash	Marks/Ch	•	June	\vdash	Drill Holes		Off-set	J					7.4.
	-	Turning S		•	\vdash	Finish		ł	Calibration					
	-	Wave/Tw	-	e		Fit/Function		ŧ	Sequence					

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Picklist Print

June-24-13 2:11:47 PM

Work Order ID:

103678

Parent Item:

D2938-1

Parent Item Name:

206 Saddle Left side

Start Date: 7/01/13

Required Date: 7/05/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B 00.06.26 New DWG rev (mpp 2069)EC IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075	,	Manufactured	No		, , , , , , , , , , , , , , , , , , ,	100	Each	48.0000	1	6	<u> 13</u>	8-19	
				Location		Loc Oty	<u>L</u> c	e Code					
				MAT042		2							
	•			984	17	2							
				MAT045		46	_						
				975	63	46							

B /03592

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DQA:			Date.			•							
						WORK ORDER NON-	-CC	ONFO	RMANCE / UI	PDATE			AEROSPACE
QA Closed:			Date:		_			<u> </u>	······································	V	ork Order up	odate only	
					!	DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Ord	er:					P l	1				` 		,
Dart i	Nο	سر				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	- Pro	Water Jet d. Eng. Coor.	Engineering Quality
raiti	10.					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR	Ν'n.					Suspected Unapproved			Large Fab	Composite	1,100,010,	Supplier	†
						' '\$	ł		·	' L	_		
Root			4.00		Desc	ription of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design	_												
Doc/Data	L	1											
Equip/Tooling		. 											
Handling/Pre Material	┝					•							
Operator													
Offset/Setup													
Process													
Supplier			1										
Training													
Transport													
Unapproved						<u> </u>							
							FA	JLT CAT	EGORY				
Landi	ng (General		l			7		7
		Bending Centre No	at Canson		\vdash	Bend BOM/Pouto		Folio/P	rogram	•	Outside Dim		Pressure/Forced
		Cracks	ot concer	זנרוכ	\vdash	BOM/Route Broken/Damage/Defect	\vdash	Grain Hardwa		<u> </u>	Over/Under		Set-up
	-	Crimp/Kir	nk/Rinnle	/\ <i>M</i> 2\/0		Burrs	H		re on Incomplete/Un	auglified	Part Incorred Part Lost/Mi		Temperature/Cure Weld
		Cuffs	туттрыс,	, ***		Contamination	Н		ions Incomplete/U	<u> </u>	Part Moved	22111R	Wrong Stock Pulled
	\vdash	Crushing				Countersink	\vdash		ned/off center	L	Positioned V	L	J WY ONE STOCK Fulled
		Heat Trea	it			Cut Too Short		Mislabe		·	Power Loss/		Other •
		Inspection		Tube		Drawing	\vdash	Misread		<u> </u>	ر. د		
		Marks/Ch				Drill Holes	П	Off-set					
		Turning S	equence			Finish		Out of C	alibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of S	equence				

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DART AEROSPACE LTD	Work Order:	103678
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Re	corded Act	tual Dimens	ions		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0:140		1,29	128	.128	128	<u> </u>	
В	0.100	0.140		1-129	-128	12/28	-128		
С	0.100	0.140		-119	1-118	-119	1/17		
D	0.210	0.230		-220	-220	-220	-220		
E	1.245	1.255		250	1,250	11.250	Laso		
L L	1.245	1.255		250	1,250	1.250	1,250		
G_	2.495	2.505		2.500	2.500	2-500	2-500		
Н	0.510	0.515		,512	,512	.512	·512		
İ	1.572	1.582		11,544	11.577	1,577	1.57	† †	
J	2.495	2.505		2,500	2,500	2,500	2,500	T	
K	0.257	0.262		-258	258	-258	258		
L	0.312	0.317		314	-314	-314	214		
M	0.235	0.240		,238	•538	.238	-23%	† .	
N	0.160	0.140		124	123	133	-123		
0	0.5407	0.560	<u>'</u>	- 549	-549	549	549		
Р	0.490	0.510		. 500	-A99	500	. 500	 	
Q	3.715	3.725	<u></u>	37720	3.720	3.720	3.720		
R	2.720	2.760		DAHO.	2-740	2.740	2.44o		<u> </u>
S	0.240	0.270		254	253	253	12253		
Т	0.100	0.180		-140	- 140	-140	- IHO		· · ·
U	1.625	1.635		050	1-630	1.630	1-630		
V	1.362	1.372		1.367	1367	1.367	1.364		
W	0.316	0.321		36	36	-316	-316		
X	1.250	1.270		1259	1.259	1.260	1,260		
Υ	1.565	1.585		1573	7.573	V 574	12591		
Z	0.178	0.198		-188	188	188	188		
AA							-100 -	 	-xt
AB						<u> </u>	·		
AC					-	 			-
AD						 		-	
AE					,	-	 		
AF		^	-				_		
AG							 	+-	
AH							 	-	
	Acc	ept/Rejec	ot	Λ 0				- - -	

			OAG
Measured by:	_ 44	Audited by	70
Date: 13-8-19	13/08/22	Date: 13 108 177	2.89
			<u> </u>

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	, , , , , , , , , , , , , , , , , , ,
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	,
С		Revised per drawing revision C	KJ/JLM_Z/L	all

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DART AEROSPACE LTD	Work Order:	103678
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

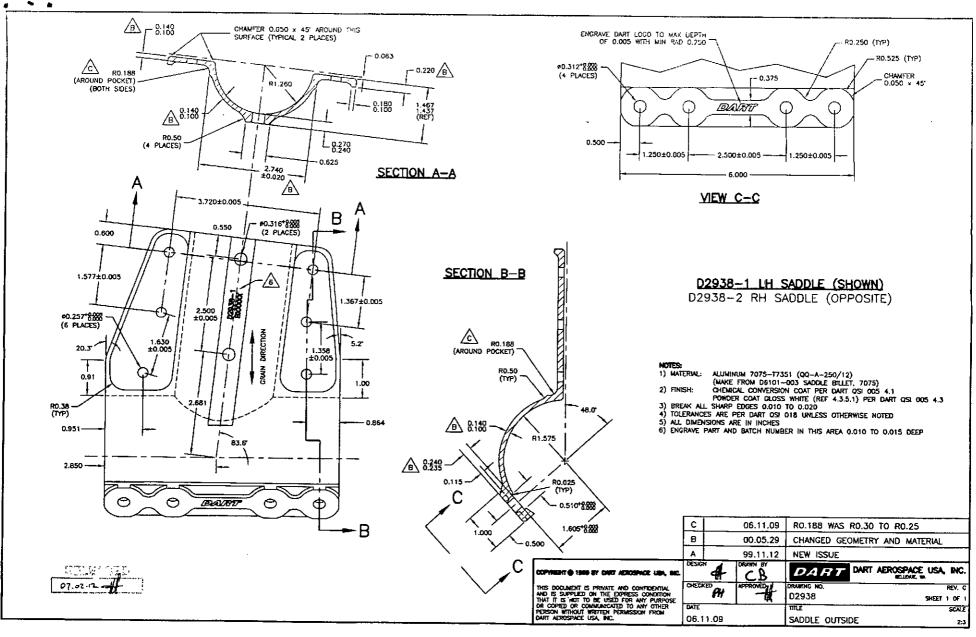
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	3	4	Ву	Date
Α	0.100	0.140		128	129			1 1	
В	0.100	0.140	· · · · · · · · · · · · · · · · · · ·	1-128	-129				
С	0.100	0.140		1-117	1-117				
D	0.210	0.230		-230	220		-		_
E	1.245	1.255		11250	11,250				· ·
F	1.245	1.255		1,250	11.256 1		-	<u> </u>	
G	2.495	2.505		2,500	2,500				
Н	0.510	0.515		25/2	.5/2				·
I	1.572	1.582		1,544	1,577				
J	2.495	2.505		2.5co	2.500			1	
K	0.257	0.262		258	.258			1	
L	0.312	0.317		-314	314			 	
М	0.235	0.240		ر <u>238</u>	- 238			+	
N	0.100	0.140		733	123			1	
0	0.540	0.560	112	-549	-549			 	
Р	0.490	0.510		-500	-500			+ +	
Q	3.715	3.725		3720	3,720				
R	2.720	2.760	<u> </u>	S 340	2.740			 	
S	0.240	0.270		2740 -252	252			+	
Ť	0.100	0.180		. 140	-140			 	
Ü	1.625	1.635	<u> </u>	1-630	[620				
V	1.362	1.372		1.367	1384			 	
W	0.316	0.321		-316	316		_		
X	1.250	1.270		1260	1,259			 	
Υ	1.565	1.585		1.574	1,574			 	
Z	0.178	0.198		-188	188				
AA		···			-101			 	
AB								+ +	
AC						+		 - 	
AD			-					 	· · · · · · · · · · · · · · · · · · ·
AE						-		+	_
AF				-				+ +-	
ĀĞ			-					 	
AH								 	
	Acc	ept/Rejec	·+	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ 	-				

		,			240
Į	Measured by:		144	Audited by	08
Į	Date:	13-8-19	13/03/22	Date: (3 108)	22 2-89
					

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	1
С	07.03.21	Revised per drawing revision C	KJ/JLM X	Cidl
				

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